

DART AEROSPACE LTD	Work Order:	24148
Description: Wearshoe	Part Number:	D2656-35
Drawing: D2656 Rev. <i>1</i>	Qty:	50
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	U	05-09-02	50
2	PG	Issue P/O: <u>2008582</u> Email or ship DXF file to vendor Laser Cut per Dwg D2656 flat pattern D2656-35 Material release note required	U	05-09-02	50
3	RG	Receive and Inspect for transit damage Ensure the material note is attached	CD	05/09/20	50
4	QC6	Inspect dimensions per template D2656-35T1	J	05-10-06	49
5	GB	Deburr if necessary			
6	GB	Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326. Identify as D2656-35.	SB	05/11/15	49
7	QC5	Inspect work to Step 6	J	05-11-16	49
8	FP	Powder Coat Grey (RAL-7012) (Ref. 4.3.5.5) per QSI 005 4.3	FC	06/01/12	49
9	QC3	Inspect Powder Coat	CD	06/01/13	49
10	FP	Identify and Stock	CD	06/01/13	49
11	AC	Cost / part:	U	06-01-13	49
12	DC	Close W/O Inspect Level 21	(J)	06/01/16	49

Rev	Date	Change	Revised By	Approved
A	97.12.04	New Issue		
B	99.03.16	Re-format	DM	
C	00.11.01	Removed P/O for powder coat – in house process	EC	
D	02.10.25	Re-format	KJ, RF	

RELEASED
02/10/30 RF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-10-06	6	destroy old template and identify new template wearplate (REV E) AS D2565-35 T1. Inspected dimensions and they're good.	<i>JM</i>	05-10-06	1	CP 05-10-06 per QSI 642	<i>JM</i> 05-10-06	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: *SP*Date: *06/01/16*

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

PRELIMINARY ISSUE

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2656
DATE 05.08.17		TITLE WEARSHOE

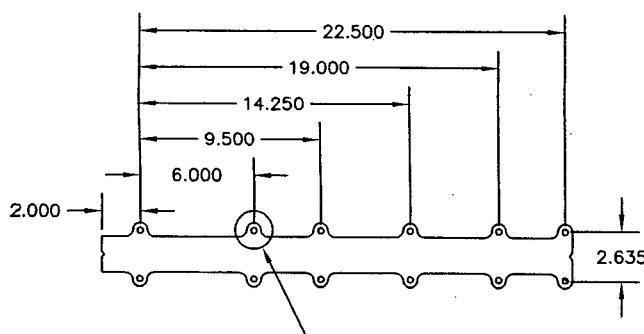
PORT HADLOCK, WA

REV. D

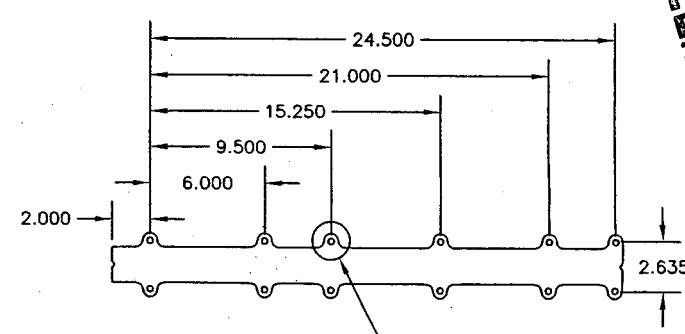
SHEET 3 OF 4

SCALE
1:10

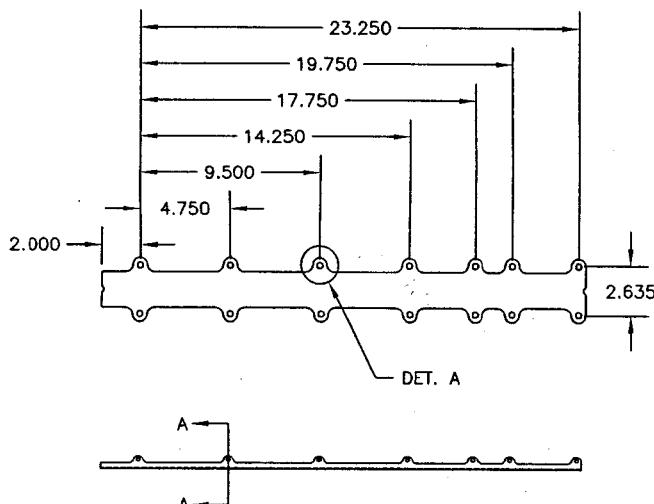
D2656-31



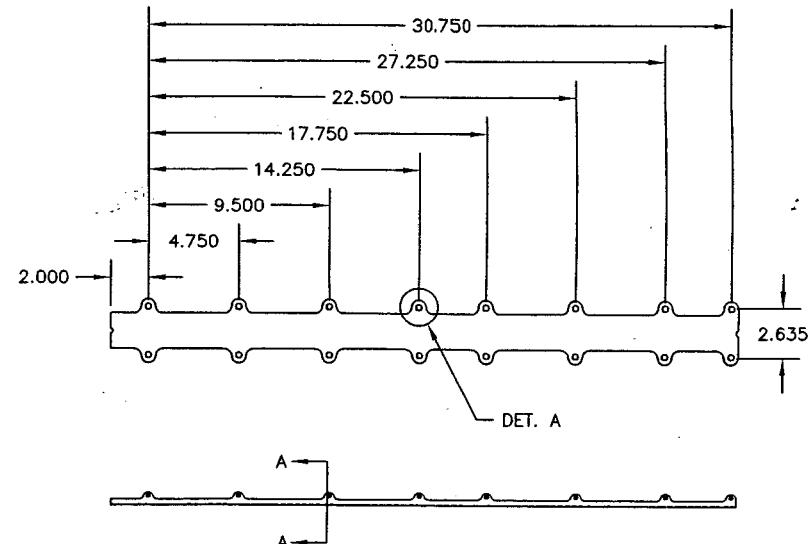
D2656-33



D2656-35



D2656-37



NOTES

MATERIAL: AISI 1000 SERIES STEEL
20 GAUGE (0.040 THICK)

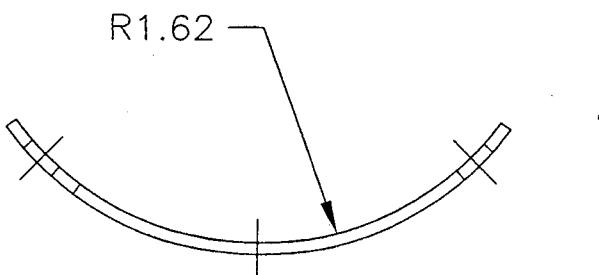
FINISH: POWDER COAT PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



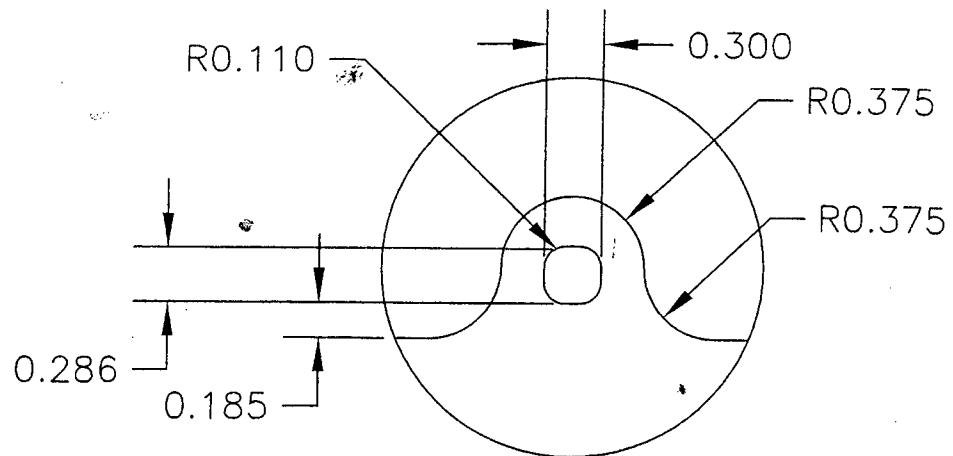
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	PORT HADLOCK, WA
DATE	05.08.17	TITLE	REV. D D2656 WEARSHOE SHEET 4 OF 4 1:10

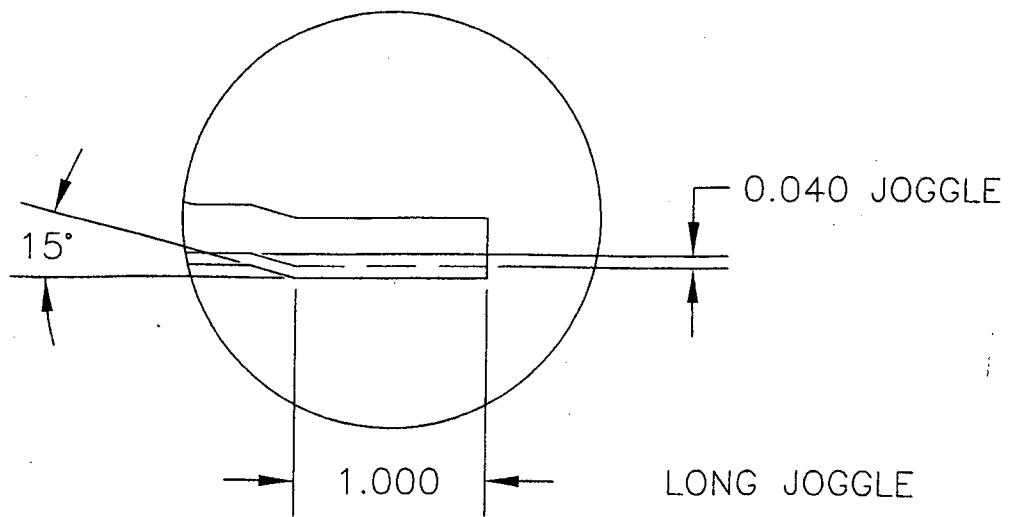
SECTION A-A



DETAIL A



DETAIL B



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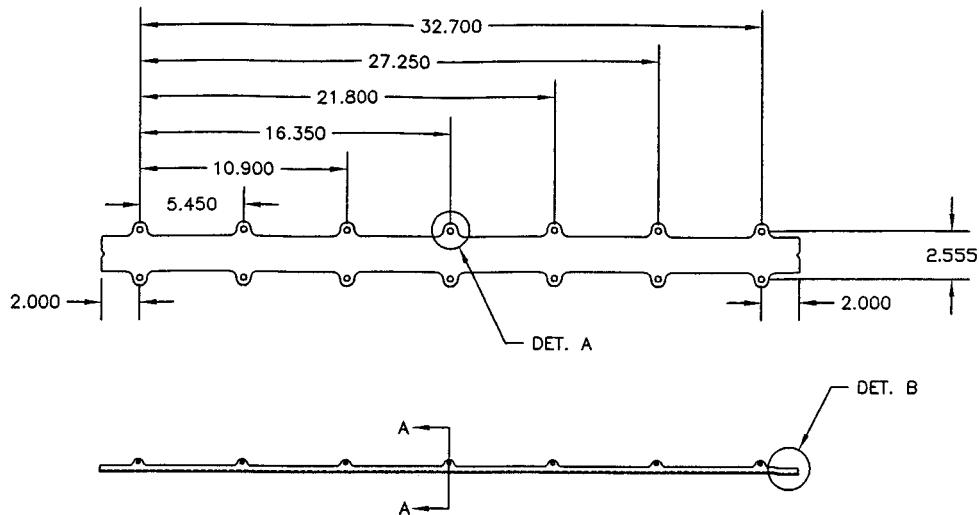


DESIGN	DRAWN BY	19	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED		DRAWING NO. D2656
DATE	05.08.17		TITLE WEARSHOE

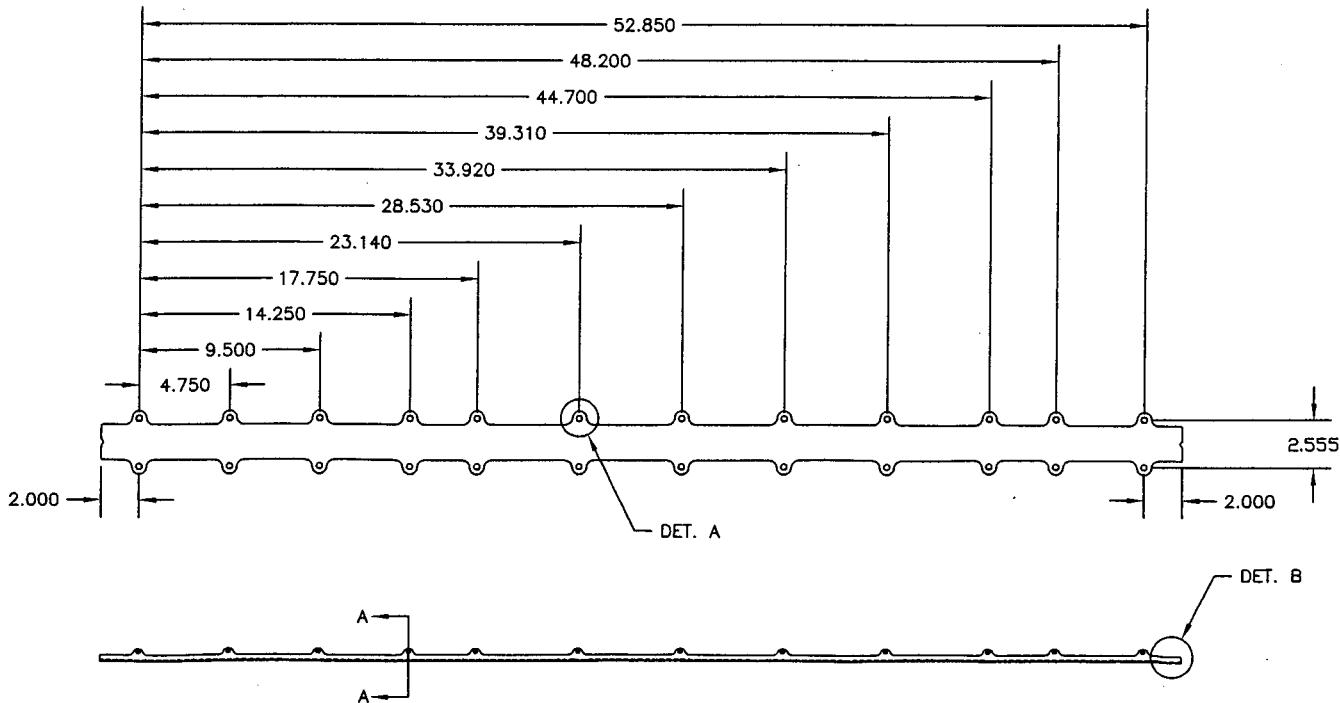
PRELIMINARY ISSUE

REV. D
SHEET 2 OF 4
SCALE
1:10

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1000 SERIES STEEL
20 GAUGE (0.040 THICK)

FINISH: POWDER COAT PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
HawkesburySep 01, 2005
10:48 am

Work Order No : 0024148
 Project Name : D2656-35
 Project For : WK537
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2656-35
 Description : Wearplate
 Manufactured : Yes
 Amount Req'd : 50
 Amount Done : 0
 Start Date : 08-29-05
 Est Finish Date : 09-16-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	0.00	0.00	0.00		
<hr/>					
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephone: (09) 375 8899 / 375 8111 Auckland
(08) 235 8089 / 235 3535 Waikato
Fax: (08) 375 8859

TEST CERTIFICATE

Ref: 5005/21329

CUSTOMER	Wilkinson	P41007DI002												SPECIFICATION ASTMA1008 CS Type A						CERTIFICATE No TC107796				
CUSTOMER O/N	90-21N-288																			PAGE	1 of 1			
MILL O/N	453665													DIMENSIONS 0.033" x 48" x Coil						DATE	31 March 2005			
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT										MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)												
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH (feet)
		x100												x1000			x10000	x100	180°					
R9-455932-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1						Good				41	
R9-455933-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1						Good				41	2621
R9-455934-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1						Good				50	2723
R9-455935-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1						Good				50	2546
																							2789	

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65" So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=0 (C)=45 (B)=190 (D)=(r+190+245)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/8 (B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/8+S/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

20 GA CRM

